

**Work Order ID 67381**

Thursday, March 17, 2011 9:53:58 AM

Page 1

Item ID: D4334-1

Accept

Revision ID: PRELIM

Item Name: Swivel

Start Date: 3/17/2011 Start Qty: 1.00

Required Date: 3/18/2011 Req'd Qty: 1.00

Reference:

*11-03-17*

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Cust Item ID:

Customer:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #  
Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4334

PA3

*PA5 11-03-17*

100

0.00

Lathe Conv

Memo

0.00

Conventional Lathe

TURN AS PER DWG  
DWG REV: *PA5*

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control



Setup

Start

Stop

*PA5 11/03/17**PA5 11/03/17*

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Item ID: D4334-1

Revision ID: PRELIM

Item Name: Swivel

Start Date: 3/17/2011 Start Qty: 1.00

Required Date: 3/18/2011 Req'd Qty: 1.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:








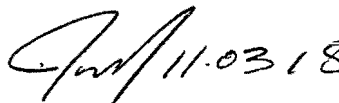
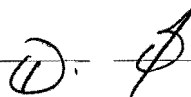
Customer:

Run Start

Stop

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Mill Conv Conventional Milling Machine	<b>Memo</b> MILL AS PER DWG DWG REV: _____  DEBURR	0.00  0.00							
130  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  <b>Memo</b>	0.00  0.00							
140  QC Quality Control	QC8- Inspect parts - second check  <b>Memo</b>	0.00  0.00							

**Work Order ID 67381**

Thursday, March 17, 2011 9:53:58 AM



Page 3

Item ID: D4334-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Swivel

Start Date: 3/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11/03/17

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11.03.18

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

ship to Eagle  
attn: Harvey.

11/3/18

RD 1370 MAR

**Work Order ID 67381**

Thursday, March 17, 2011 9:53:58 AM

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Item ID: D4334-1

Accept

Revision ID: PRELIM

Item Name: Swivel

Start Date: 3/17/2011 Start Qty: 1.00

Required Date: 3/18/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE

RELEASED

DATE

RD1370

# Picklist Print

Page 1

Thursday, March 17, 2011 9:53:51 AM

Work Order ID: 67381



Parent Item: D4334-1



Parent Item Name: Swivel

Start Date: 3/17/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-02-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased		No		100	f	50.2181	0.125	0.131579			

6061-T6 Round Bar 1.250

Location

Loc Qty

Loc Code

MAT013

50.21805

113457

31.21805

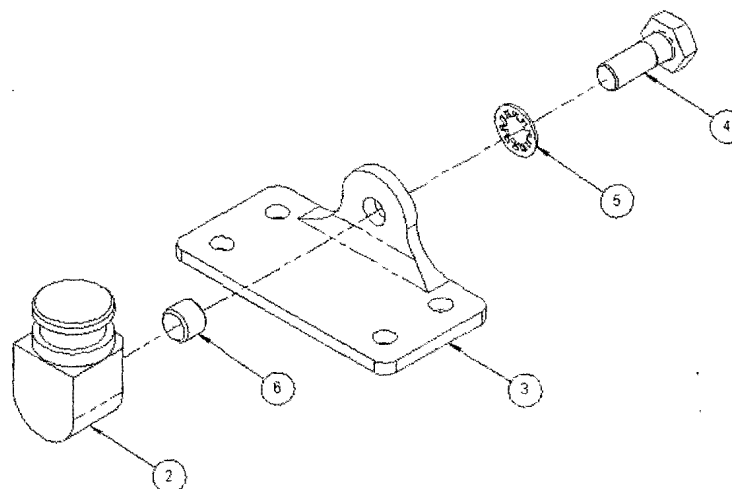
113550

19

.150 11/03/17



ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION
1	X	D4334-041	BRACKET ASSEMBLY
2	1	D4334-1	SWIVEL
3	1	D4334-3	BASE
4	1	AN4-5A	BOLT
5	1	MS35333-125	LOCK WASHER
6	1	90296A208	HELI-COIL



**D4334-041 BRACKET ASSEMBLY**

**PRELIMINARY ISSUE**

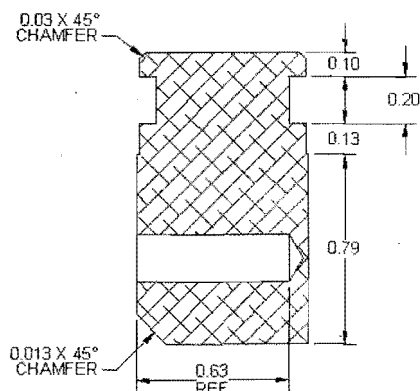
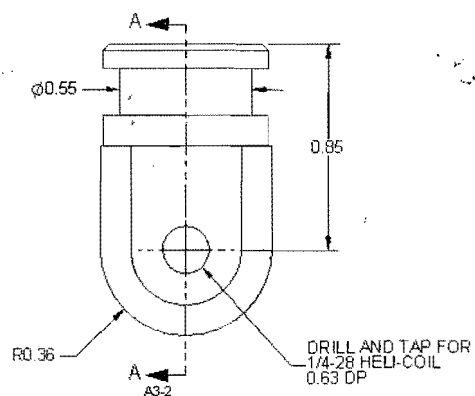
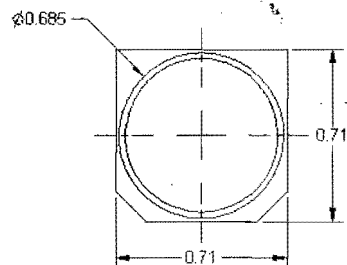
11.02.10

**NOTES**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs

PA5	NEW ISSUE	11.02.10
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED	N/A	
DE APPR.	N/A	
DATE	11.02.10	

<b>DART AEROSPACE LTD</b> HAMKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4334</b>	REV. PA5 SHEET 1 OF 4
TITLE <b>BRACKET</b>	SCALE NTS
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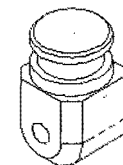
**SECTION A-A** B6-2

**D4334-1 SWIVEL**

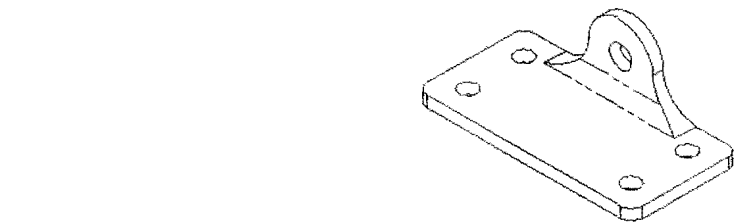
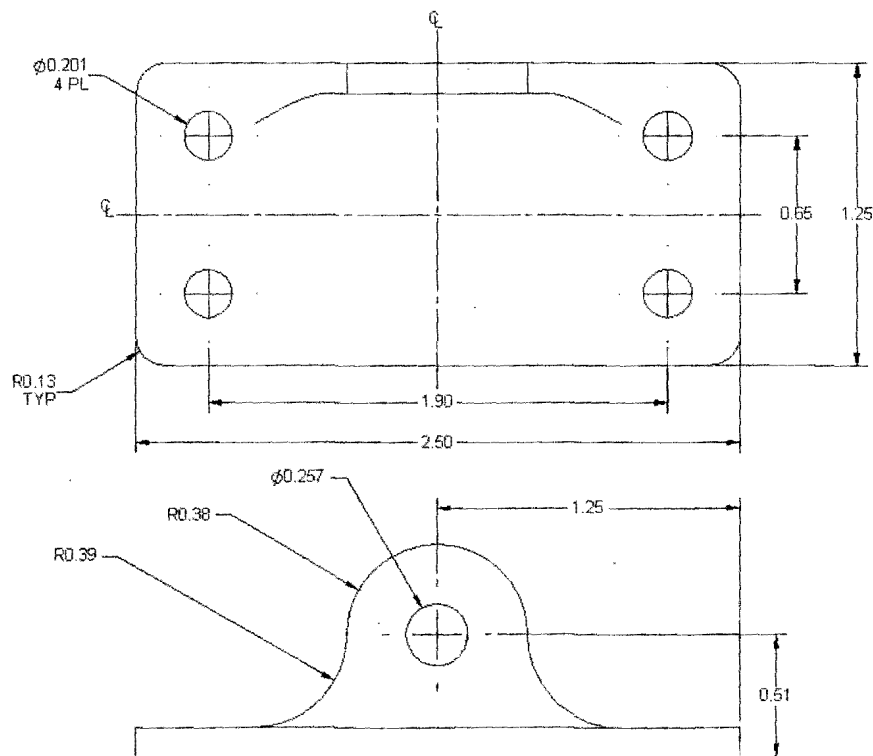
**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

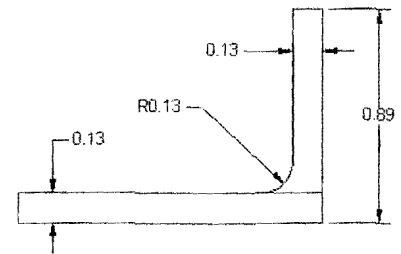
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CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		<b>D4334</b>	SHEET 2 OF 4
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	<b>BRACKET</b>	NTS
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w/o 67321



**D4334-3 BASE**

**NOTES**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
REF DART SPEC M6061 T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. PA6
MFG. APPR.		<b>D4334</b>	SHEET 3 OF 4
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	<b>BRACKET</b>	NTS
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